

Work Order ID 163205-2

Monday, June 26, 2017 10:08:06 AM

163205

Page 1

Item ID: D4704-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Expandable Pin Assembly

Start Date: 6/28/2017 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 6/28/2017 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: N Date: JUN 26 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4704	B								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE SPRING CLIP AS PER DWG								
	ENLARGE D4308-11 HOLES TO 0.209								

5 JUL 06 2017 DAS
6
9-89

4X

DAS
36
17/09/17

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Accept

N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Expandable Pin Assembly

Start Date: 6/28/2017 Start Qty: 5.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4	0	SEP 07 2017	DAS 19 9-89 DAS 9 9-89
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST110</i> Memo	0.00 0.00				4		SEP 12 2017	DAS 6 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						17/9/18	

SEP 13 2017

Picklist Print

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Work Order ID: 163205

163205

Parent Item: D4704-043

D4704-043

Parent Item Name: Expandable Pin Assembly

Start Date: 6/28/2017

Required Date: 6/28/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS IPP REV:B
17.01.11 PRELIM rev.b DWG DD VERF:JLM IPP REV:C 17.05.29
AS PER DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4708-11 *D4708-11* Lanyard		Manufactured	No				Each	15.0000	**	5		JUL 06 2017	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST120			15						
					162300		15			5			
D4709-3 *D4709-3* Spring Clip		Manufactured	No				Each	20.0000	**	5		JUL 06 2017	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST120			20						
					162272		20			5			
D4709-4 *D4709-4* Spring Clip		Manufactured	No				Each	20.0000	**	5		JUL 06 2017	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST120			20						
					162271		20			5			
D4711-041 *D4711-041* Expandable Pin Assembly, Modified		Manufactured	No				Each	1.0000	**	10		JUL 06 2017	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST120			1						
					161977		1						

B 162299 10

Picklist Print

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Work Order ID: 163205

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Parent Item: D4704-043

D4704-043

Parent Item Name: Expandable Pin Assembly

Start Date: 6/28/2017

Required Date: 6/28/2017

Start Qty: 5.00

Required Qty: 5.00

MS20613-4C8

Purchased

No

Each

133.0000

30

MS20613-4C8

**

Rivet

Location

Loc Qty

Loc Code

GA

133

120242

133

8

~~12/09/07~~ 36 38

MS20613-4C 7

M 133323

(6x)

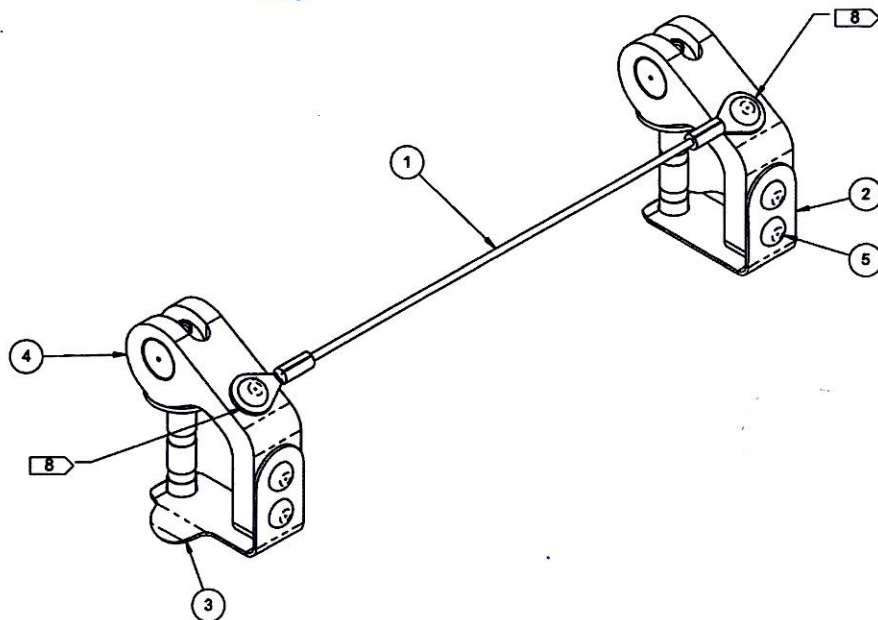
M 138043

(18x)

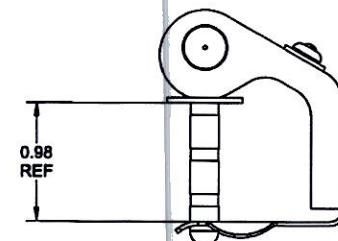
17/09/07 DAS 36 38

ITEM	QTY	P/N	DESCRIPTION
	X	D4704-043	EXPANDABLE PIN ASSY
1	1	D4708-11	LANYARD
2	1	D4709-3	SPRING CLIP
3	1	D4709-4	SPRING CLIP
4	2	D4711-041	EXPANDABLE PIN, MODIFIED
5	6	MS20613-4C8	RIVET

4 or -4C7 DAS 22 17.07.12
9-89



D4704-043 EXPANDABLE PIN ASSY



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4704-043" AND B/N "BXXXXX" PER QSI 044 6.7
- 7) WEIGHT: 0.39 lbs
- 8) ENLARGE D4708-11 HOLES TO $\phi 0.209$

RELEASED

2017 MAY 24

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	EUGENE, OR	
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4704	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	EXPANDABLE PIN ASSY	NTS
DATE	17.02.02	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

D4708-11

DAS 22 9-89

17.07.12